

Date: Wednesday, 18/03/2009 7:11:46 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI-ACCESS STEP LH (FOLDING)
Job Number	: 46548	Part Number	: D412630033
Estimate Number	: 12567	Drawing Number	: IIN D412-630
P.O. Number	:	Project Number	: N/A
This Issue	: 18/03/2009 S.O. No. :	Drawing Revision	: M
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : LARGE FAB ASSY	Due Date	: 30/03/2009
Previous Run	: 46297	Qty:	3 Um: Each
Written By	:		
Checked & Approved By	: <u>MF 09-03-18</u>		
Comment	: Est. Rev:A New Issue 06-11-08 JLM est rev B ecn 1019, added d2807-041 EC verified by:DD Est Rev:C 09-03-02 as per rev.m DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-033 CHG003



2.0	D2012107	Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description
1	D2012-107	Clevis

Batch

45074

3.0	D2803041	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2803-041	Bracket Assembly LH

Batch

41672

4.0	D2804041	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2804-041	Bracket Assembly LH

Batch

46331

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Seq. #:

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Description :

5.0

D2807041

Door prop



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~8.0000~~ ⁴ Each(s)

Support Prop

Batch: 43901

SS 09/03/19 (X3)

6.0

D2813

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~8.0000~~ ⁶ Each(s)

Washer

Pick:

Qty	Part Number	Description
2	D2813	Washer

Batch

411667

SS 09/03/19 (X3)

7.0

D3562041

Step Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~4.0000~~ ³ Each(s)

Step Weldment LH

Pick:

Qty	Part Number	Description
1	D3562-041	Step Weldment LH

Batch

B46181

SS 09/03/19

8.0

D33951

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~46.0000~~ ¹² Each(s)

Bushing

Pick:

Qty	Part Number	Description
4	D3395-1	Bushing

Batch

46435

SS 09/03/19 (X3)

9.0

AN3C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: ~~8.0000~~ ⁶ Each(s)

BOLT

Pick:

Qty	Part Number	Description
2	AN3C21A	Bolt

Batch

~~M109148x~~
M101189x6

SS 09/03/19 (X3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation: Description :

10.0 AN8C16 Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: ⁶8.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

~~M109~~ M105969

SS 09/03/19 (S)

11.0 AN310C8 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: ⁶~~8.0000~~ Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

M109148

SS 09/03/19 (S)

12.0 MS24665302 Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total: ⁶~~8.0000~~ Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M106763

SS 09/03/19 (S)

13.0 NAS1515H3 Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: ¹⁸~~24.0000~~ Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

M109268

SS 09/03/19 (S)

14.0 NAS1515H5L WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: ¹²~~16.0000~~ Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M108964

SS 09/03/19 (S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 46548

Part Number: D412630033

Job Number:



Seq. #:	Machine Or Operation:	Description :
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15.0	NAS1515H8	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~16.0000~~ 12.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

M109099 x12

28/09/03/18 (3)

16.0	MS210433	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total: ~~16.0000~~ 12.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M110562

28/09/03/18 (3)

17.0	MS24693C280	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101390

28/09/03/18 (3)

18.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M109929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON

BATCH: M104251

28/09/03/19 (3)

19.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

28/03/19 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 46548

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-1	Bushing	4274

4274

SS 09/03/19 13

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2806-3	Bushing	34275

34275

SS 09/03/19 13

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Strut

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	D2810-5	Strut	344552

344552

SS 09/03/19 13

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Spacer

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D3396-1	Spacer	41670

41670

SS 09/03/19 13

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
			M 109147

M 109147

SS 09/03/19 13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 46548

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 AN4C6A Bolt

26.0 AN4C10A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C10A	Bolt	M164679

SS 09/03/1903

27.0 AN4C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN4C15A	Bolt	M167082

SS 09/03/1903

28.0 AN4C7A Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C7A	Eyebolt	M160440

SS 09/03/1903

29.0 AN5C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN5C15A	Bolt	M169148

SS 09/03/1903

30.0 NAS1515H4 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 28.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H4	Washer	M169267

SS 09/03/1903

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

NAS1515H5

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 28.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

Description

Batch

7 NAS1515H5

Washer

M109430

8/809/03/1903

32.0

MS210434

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21043-4

Nut

M111125

8/809/03/1903

33.0

MS210435

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

Description

Batch

3 MS21043-5

Nut

M110123x6
M109053x3

8/809/03/1903

34.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

0903-17 (3)

Kits separated.

8/809/04/01

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-033

Location:

PPP Rev:

A

9/4/12

59

36.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/08

Job Completion



MF 09-04-07

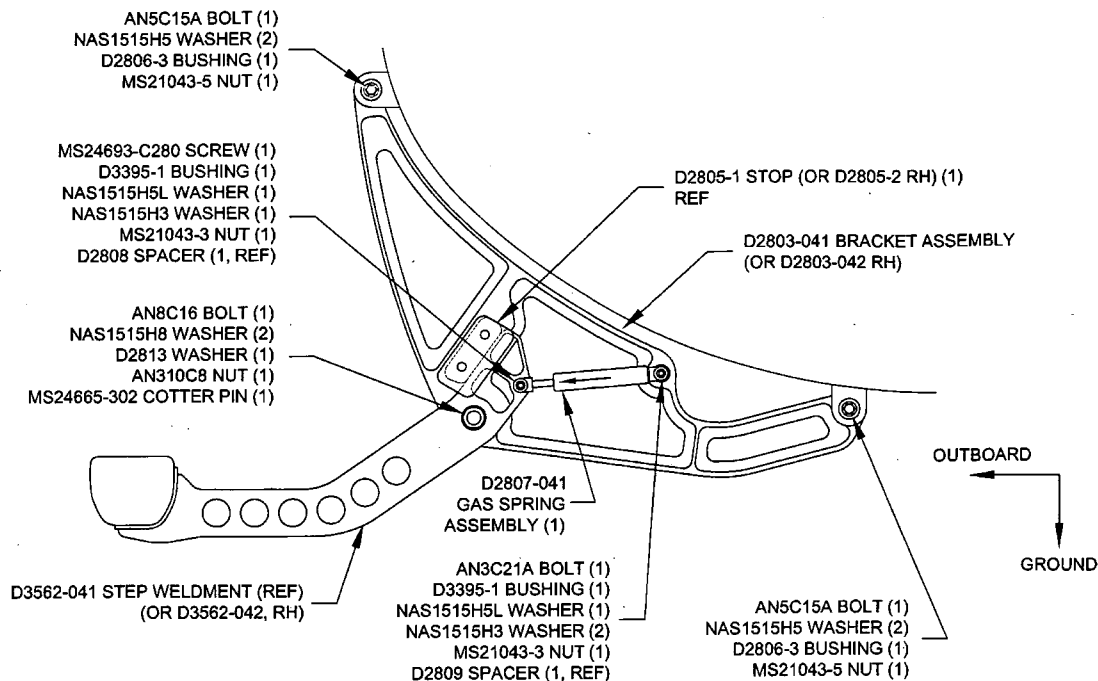
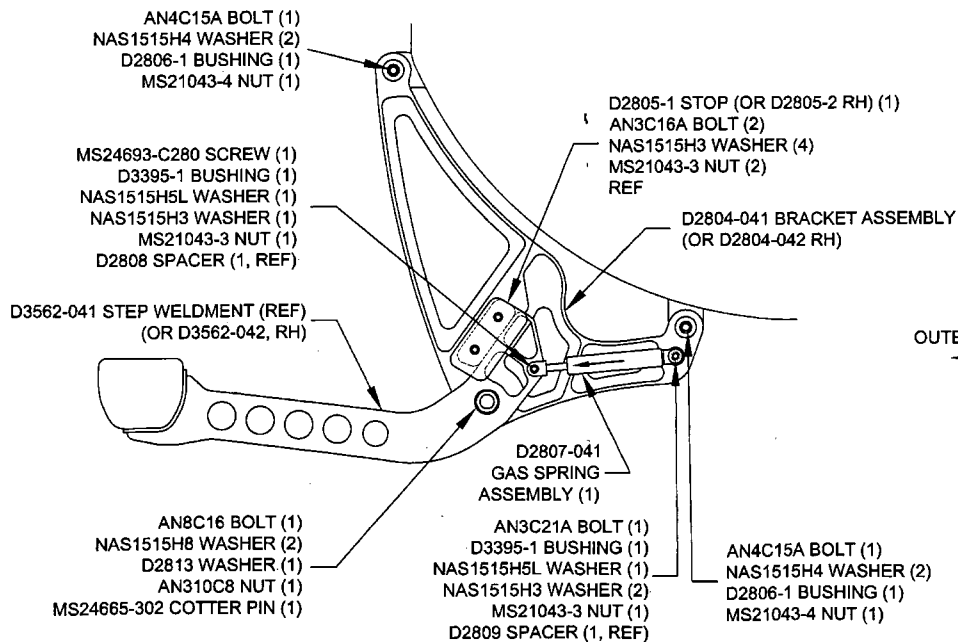
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NOTE: Date & initial all entries

D412-630-033/-034 Heli-Access-Step™ Installation**FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)****FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)**

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Revision: **M**
Date: 08.12.12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46548

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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